

Work Order ID 48227

June 26, 2009 7:26:45 AM



Page 1

Item ID: D2199-1

Accept



Setup Start



Revision ID: E1

Item Name: Strut Details

Stop



Start Date: 15/07/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2199

Rev E1

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch per Dwg. D2199 and Spec Control Dwg D2638

SJB 09/07/06

(5)

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr

M.L 09/07/07

(5X)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> SJB 09/07/07 (X5)

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QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

1:00pm

OVEN TEMPERATURE:

1:30pm FINISH TIME:

400°F

1111472 09-07-07 (X5)

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

HL 09-07-7 (5)

150

Identify as per dwg & Stock Location: ST 258

0.00



Packaging

Memo

0.00

Packaging

PC 9/7/7 (5)

Work Order ID 48227

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Page 3

Item ID: D2199-1

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Item Name: Strut Details

Start Date: 15/07/2009 Start Qty: 5.00

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/07/09

WF 09-07-07

Picklist Print

June 26, 2009 7:26:45 AM

Page 1

Work Order ID: 48227

Parent Item: D2199-1RevE1

Parent Item Name: Strut Details


Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	0.0000	8.1579			
										M 111 619	28 07/07/09	3
304 RD Tube .750 x .049W												

Date: Thursday, 28/05/2009 9:11:21 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT
Job Number : 48227	
Estimate Number : 10200	
P.O. Number :	Part Number : D21991
This Issue : 28/05/2009 S.O. No. :	Drawing Number : D2199 REV. E1
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : E1
Previous Run : 43596	Material :
Written By :	Due Date : 12/06/2009 Qty: 5 Um: Each
Checked & Approved By : <u>JULIE DAWSON</u>	
Comment : Est B 02.06.10 Added finish NG/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	✓ M304TR0750W049	304 RD Tube .750 x .049W
-----	------------------	--------------------------



Comment: Qty.: 1.6275 f(s)/Unit Total : 8.1375 f(s)
 Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall
 (M304TR0750W049) Batch No: _____

2.0	✓ BRAKE NC	NC BRAKE
-----	------------	----------



Comment: BRAKE NC
 Punch per Dwg. D2199 and Spec Control Dwg D2638

3.0	✓ SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	---------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

4.0	✓ QC5	INSPECT WORK TO CURRENT STEP
-----	-------	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

5.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING
 Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 1:00pm
 OVEN TEMPERATURE: 400°C
 FINISH TIME: 1:30pm

JHL 09-07-07 (X5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 28/05/2009 9:11:21 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 48227

Part Number: D21991

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

bl 09-07-7 (S)

7.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

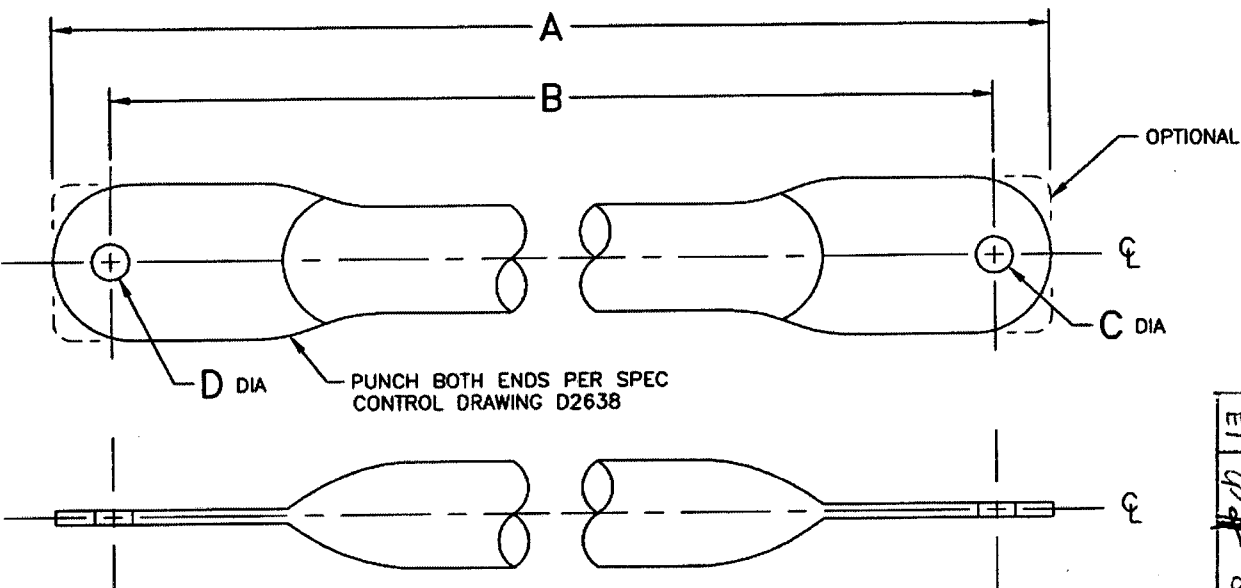
NOTE: Date & initial all entries



RELEASED
48.05.05 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	DRAWING NO.	TITLE	REV. E
98.04.28	D2199	STRUT DETAILS	SHEET 1 OF 1
		SCALE	NIS

A	1993	NEW ISSUE
B		ADDED -11, -13, AND -15
C		ADDED -17 AND -19
D		ADDED -21
E	98.04.28	ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD
E1	02.05.22	ADD FINISH



	A	B	C	D
D2199-1	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

B
B
B
C
C
C
D
E
E

00.10.13
00.10.13

- NOTES:
1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
 2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.750 x 0.049 WALL
 3. FINISH: POWDER COAT WHITE (4.3.5.2) PER DART Q51 CUS 4.3/ET

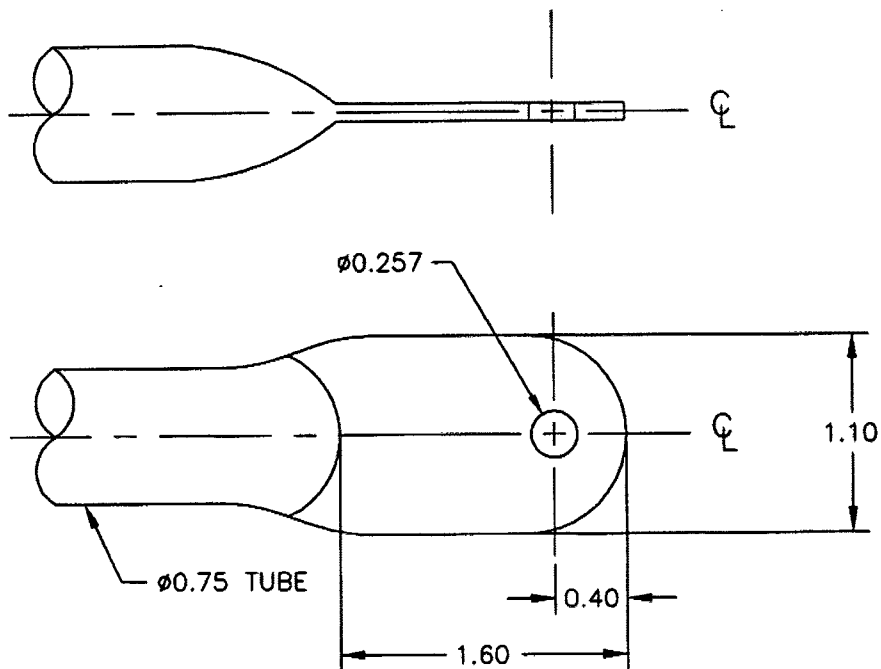
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WORK ORDER
NO. 11622



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MB	APPROVED KE	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
4/5/05 KE

SPECIFICATION CONTROL DRAWING
FOR PUNCH DT8117



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